



Dart Aerospace Ltd.
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C45-19C
Job Sheet 191788



Part No: C45-19C

Job Qty: 1 pcs

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: C45-19C REV.5 IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Large Fab - Welded Assy-1	1 pcs	4/12/19		0.00	10.00	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	
							Large Fab - 3	
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	CC
							Large Fab - 8	
110	QC 9	1 pcs	4/12/19		0.00	0.00	Large Fab - 9	JY
							QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	DAS
							QC 9 - 50	43
120	QC 5	1 pcs	4/12/19		0.00	0.00	9-89	
							QC 9 - 9	
							QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 42	DAS
							QC 5 - 43	43
							QC 5 - 49	9-89
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	



Container No: S183319



Part: C45-19C

Job No: 191788

Serial No/Batch: S183319

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 05/23/19

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					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130	Powdercoat - 6 Fire Red B4B	1 pcs	4/12/19	0.00 0.50	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 14-5-23
					Powdercoat - 4 - B4B	
140	QC 3	1 pcs	4/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	DAS 30 9-89
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
150	Packaging 3-2 - Stock - B4B	1 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS 30 9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	

					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	1 pcs	4/12/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Fabricate per Drwg)1-MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: 21 USE 268

Descriptions: WELDING JIG C45. 2-Weld as per DWG. ***SEE NOTE 1, ALL HOLES MUST ALIGN***

110 - QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3)START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

140 - (QC3- Inspect Part Finish)

150 - Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C45-18-1	Lifting Plate	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5178742
C45-18-5	Boss	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5120955
C45-18-6	Bumper Bracket	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5163907
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 10.5000 ft (10.5 ea) 0.120" Wall		100-Large Fab - Welded Assy-1	5173547 5176182

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	C45-18-1	2	2	0
	C45-18-5-PO	2	0	0
	C45-18-6	1	1	0
	MT-A513-T-1.000W0.120	11	120	0

Part Specifications

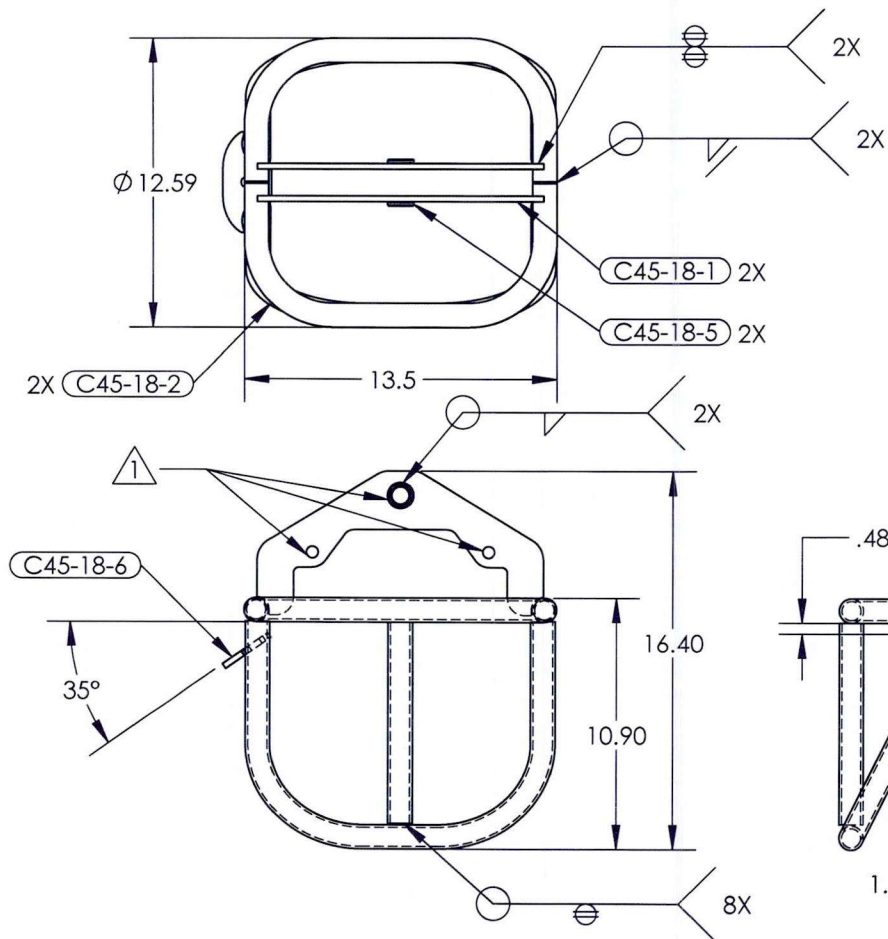
Specifications could not be found.

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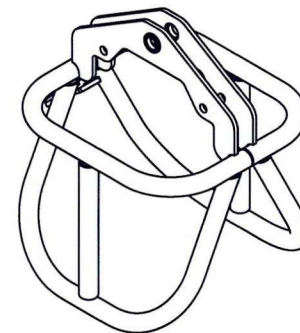
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
3		AS DRAWN BY CANAM.	11/16/2012	JAG
4	15-0087	UPDATED TO NEW DRAFTING STANDARDS. CH'D WIDTH BETWEEN LIFING PLATES WAS 1.14 IS 1.16 +.02 -.00. CH'D DIM WAS 1.29 IS .48. DELETED DIM .250. ADDED FIXTURE NOTE.	4/16/2015	RJC
5	16-0207	DELETED POWDER COAT RED FINISH SPEC, DELETED MATERIAL COLUMN FROM BOM. CH'D DWG TO SHEET METAL TOLERANCE.	11/2/2016	RJC



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WITHOUT NOTICE
WORK ORDER
NO. 191788 MJS
19-03-08



NOTES:

1. THREE HOLES MUST BE ALIGNED FROM FRONT PLATE TO THE BACK PLATE.
2. ASSEMBLE USING FIXTURE C45/C60-F.

B/O	Part #	UNIT QTY	Description
	C45-18-1	2	LIFTING PLATE
	C45-18-2	2	TOP SEMI-RING
	C45-18-3	2	SIDE LOOP
	C45-18-4	2	STIFFENER BAR
	C45-18-6	1	BUMPER BRACKET
	C45-18-5	2	BOSS

DART AEROSPACE	
TITLE WELDMENT C45 CAGE	
DWG NO. C45-19C	REV 5
MAT'L FINISH TREAT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
DRAWN BY: APICAL INDUSTRIES CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
SCALE 1:8	DATE 7/21/2009
SHEET 1 OF 1	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					